

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 141243

Tuesday, February 02, 2016 12:57:15 PM

141243

Page 2

Item ID: D5394-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Bushing
Start Date: 2/2/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 2/5/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120						(5)			
QC	Memo	0.00							
Quality Control									FEB 03 2016

130	Identify as per dwg & Stock Location: <u>PRELIM</u>	0.00							DAS 38 9-89
130									
Packaging	Memo	0.00							
Packaging									FEB 03 2016

POSITIVE RECALL

EFFECTIVE 16.2.2 AUTH (4)

RELEASED 9
9-89

DATE 16.03.15

as per dwg. Rev A

140	QC21- Final Inspection - Work Order Release	0.00							DAS 38 9-89
140									
QC	Memo	0.01							
Quality Control									FEB 03 2016

ML5

MAR 11 2016

ML5

FEB 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

Picklist Print

Tuesday, February 02, 2016 12:58:29 PM

Page 1

Work Order ID: 141243

141243

Parent Item: D5394-1

D5394-1

Parent Item Name: Bushing

Start Date: 2/2/2016

Required Date: 2/5/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.4375		Purchased		No			f	18.4160		0.252632			
M304R0 4375									**			16/02/03	DAS
304 ROUND BAR 0.4375													40
													9-55

Location

Loc Qty

Loc Code

MAT029

18.416

→ 116112

18.416

0.35

DQA: _____ Date: _____



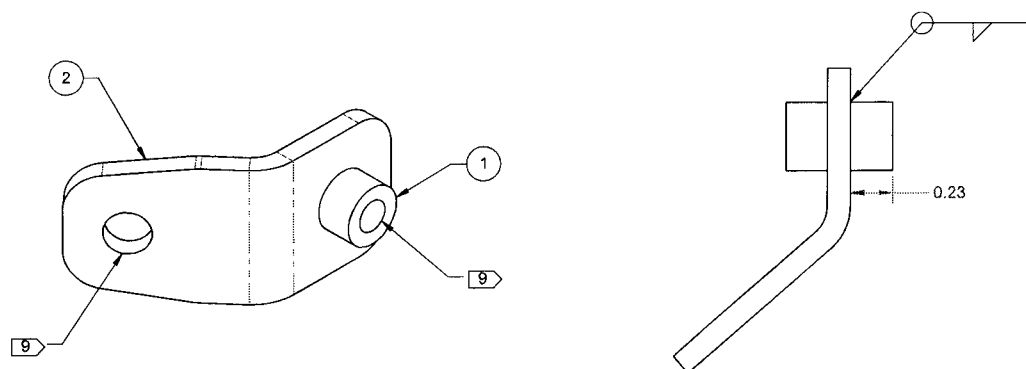
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5394-041	BRACKET ASSEMBLY
1	1	D5394-1	BUSHING
2	1	D5394-3	BRACKET



D5394-041 BRACKET ASSEMBLY

PRELIMINARY ISSUE

16.02.02 KJ

NOTES:

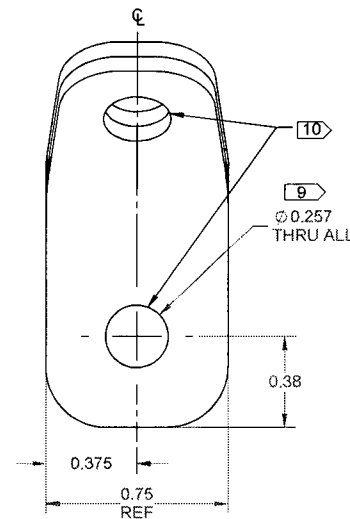
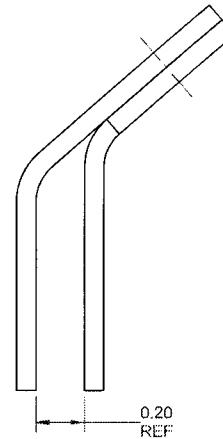
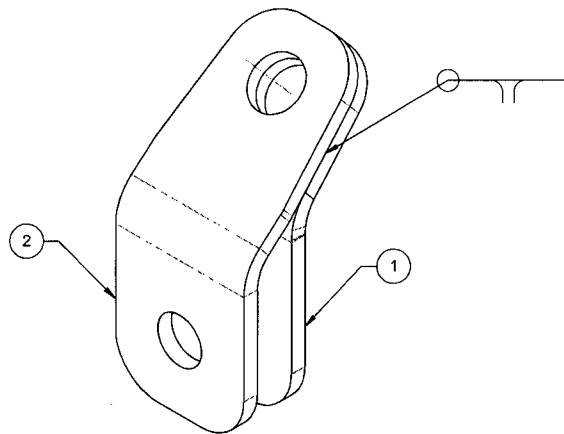
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT

A	NEW ISSUE	RF	16.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5394	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	16.01.27	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

UNAPPROVED

16.02.02
141243

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5394-043	BRACKET ASSEMBLY
1	1	D5394-5	BRACKET
2	1	D5394-7	BRACKET



D5394-043 BRACKET ASSEMBLY

PRELIMINARY ISSUE

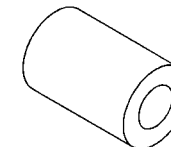
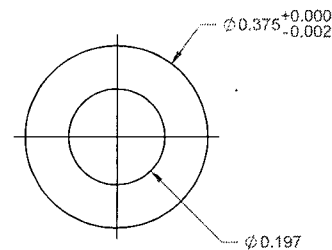
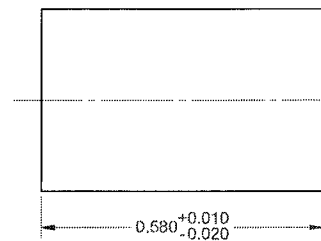
16.02.02 KJ

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL AFTER WELDING
- 10) MASK HOLES PRIOR POWDER COAT

UNAPPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A4
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D5394-1 BUSHING

PRELIMINARY ISSUE

16.02.02 KJ

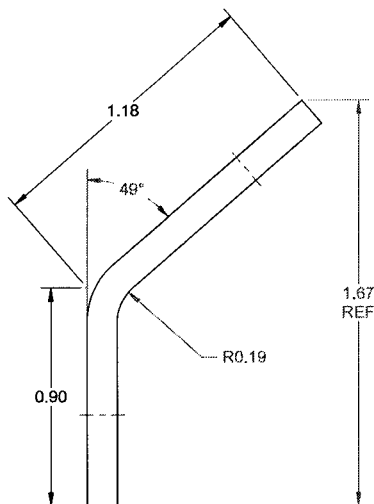
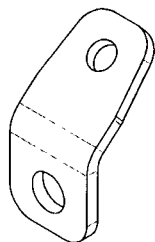
NOTES:

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND BAR
PER ASTM 276
REF. DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

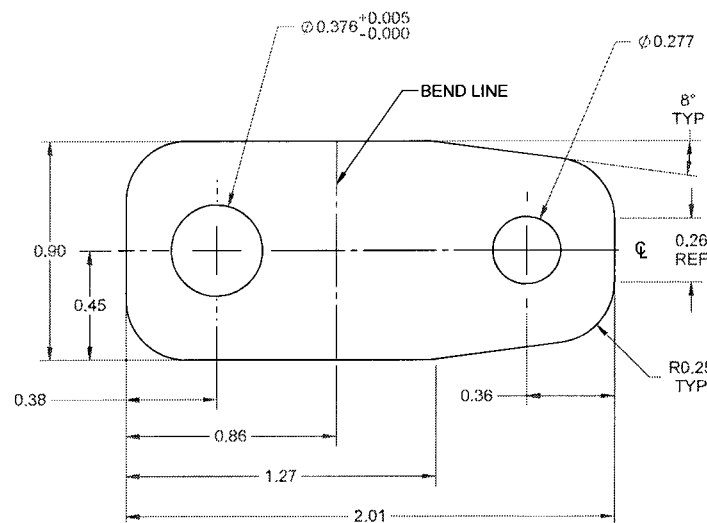
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DRAWN	RF		
CHECKED	VS	DRAWING NO. D5394	REV. A4
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APPROVED			SCALE NTS
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DATE	16.01.27		

13



D5394-3 BRACKET
(MAKE FROM D5394-3F)



D5394-3F FLAT PATTERN

PRELIMINARY ISSUE

16.02.02 KJ

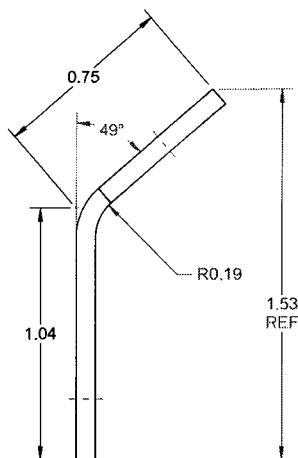
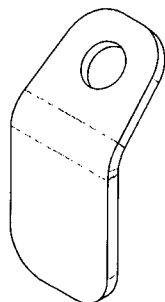
NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.125 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

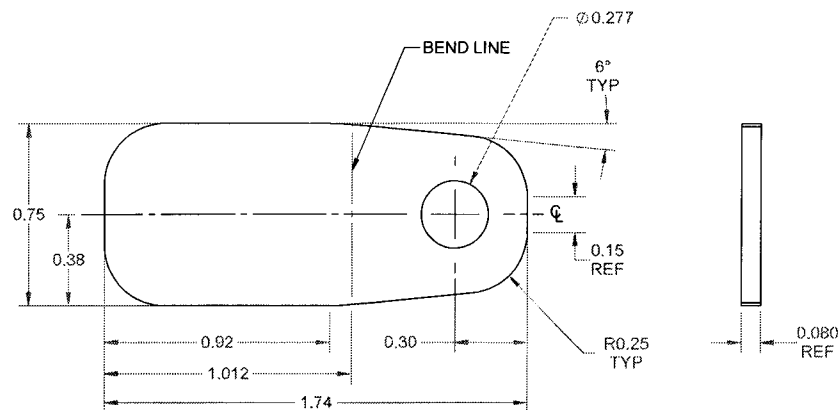
UNAPPROVED

DESIGN	RF
DRAWN	RF
CHECKED	VS
MFG. APPR.	DD
APPROVED	
DE APPR.	
DATE	16.01.27

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5394	REV. A4
TITLE BRACKET	SHEET 4 OF 6
SCALE NTS	
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D5394-5 BRACKET
(MAKE FROM D5394-5F)



D5394-5 FLAT PATTERN

PRELIMINARY ISSUE

16.02.02 KJ

NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.080 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S14GA OR M303S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

UNAPPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5394	SHEET 5 OF 6
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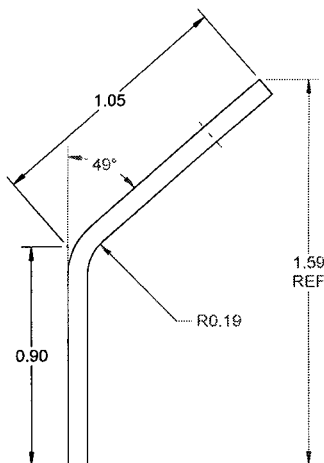
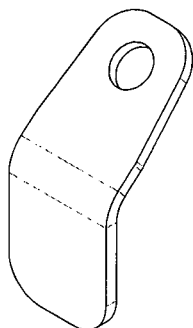
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D

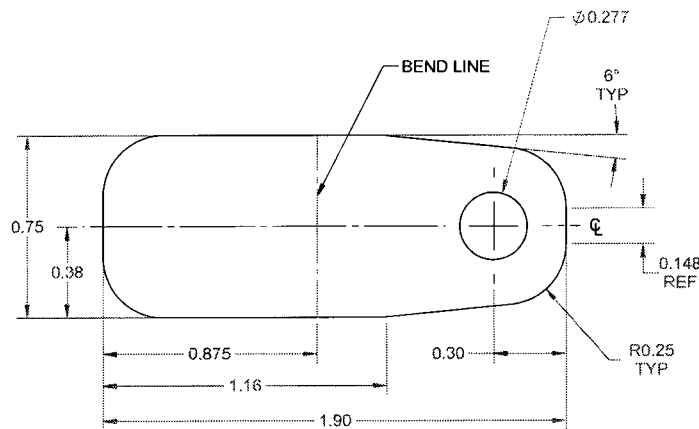
C

B

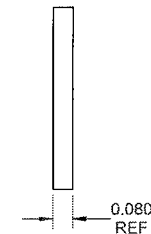
A



D5394-7 BRACKET
(MAKE FROM D5394-7F)



D5394-7 FLAT PATTERN



PRELIMINARY ISSUE

16.02.02 KJ

NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.080 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S14GA OR M303S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

UNAPPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5394	SHEET 6 OF 6
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8 7 6 5 4 3 2 1

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Purchase Order Receipt Listing

Page 1 of 1

Wednesday, November 10, 2010 3:09:04 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO12847 Receipt Dates from 11/10/2010 to 11/10/2010 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MET001	Metaux Castle								
PO12847	2		M304R0.4375	f	11/11/2010	11/10/2010	12.0000	\$29.42	0.0000	0	\$353.01
CAD	No		304 ROUND BAR 0.4375 116112	f	12.0000	DESJ02		\$353.01	0.0000	0	
								Total Received Quantity:			12.0000
								Total Qty to Inspect (PO U/M):			0.0000
								Total Reject Quantity:			0.0000
								Total Receipt Value:			\$353.01
								Total Balance Due Quantity:			0.0000

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Shipment No:562673

Ship From: Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 09-NOV-10	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 562673-2	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No 1087772	Line No 2	Item No 13481	Description 0.4375.RD.304/304L.STAINLESS.CF.ANN.144.0000 SPECIFICATIONS: ASTM A276				
Purchase Order No 12847		Part Number		Ordered Qty 144 FT		Invoice Qty 12 PCS	
Details							
Delivery No. 53950312	Mill	Heat Number 3WY1	Mech Id	PCS 12	Width (IN)	Length (IN) 145	Shipped Qty (LBS) 75

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

AMERICAN STAINLESS INSPECTION CERTIFICATE

Email: customerservice@northamericanstainless.com

8
10/11/11

CUSTOMER

A.M. CASTLE & COMPANY

TOLERANCE

ASTM-A-484-00

PRODUCT

Round bar, annealed, cold drawn.

ORDER NUMBER	MARK# / PROD ID	HEAT NUM	WEIGHT
LN45276	76001/BC03051	3WY1	2196

CASTLE METALS CORP
OFFICE
APPROVED BY
13481/12/08

REQUIREMENTS AISI

LENGTH

12.00 ft

SIZE

4375 Inches

SURFACE AND DIMENSION CONTROL WITHOUT OBJECTIONS

INTERGRANULAR CORROSION
ASTM A262-02a
PRACTICE B-
Acceptable

MECHANICAL PROPERTIES

HEAT NUM	UTS KSI	.2 YS KSI	B10-10 %	RA %	HB No.	Charpy P/T												
3WY1	168	84	54	70	202	F												
Req Values	90 125	45 108	30 100	40 100	140 242													

HEAT NUM																		
3WY2																		
Req Values																		

CHEMICAL COMPOSITION %

CM(Country of Melt) ES(Spain) US(United States)

CM	HEAT	C	P	S	Si	Mn	Cr	Ni	Mo	Ti	N	Cu	Co	Cb				
US	3WY1	.0252	.0235	.0294	.4377	1.3450	18.2063	8.9284	.0660	.0044	.0761	.1315	.0896	.0049				
REQUIRED VALUES		.0300	.0450	.0300	1.0000	2.0000	18.0000 20.0000	8.0000 12.0000			.1000							

OBSERVATIONS/SPECIFICATIONS

UNS-S30400, UNS-S30403, COLD DRAWN BAR, ASTM A276-04, ASTM A479-04, ASTM A484-03, ASTM A193-03(EXC PAR 6.3)
AMS 5639H, AMS 5647H, AMS-QQ-S-763A, ASME SA479-04, ASME SA193-04(EXC PAR 6.3), EN 10204 3.1B, QQS-763F,
Macro and micro test: Satisfactory.

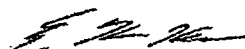
ASTM A182-02(CHEM ONLY), ASME SA182-04(CHEM ONLY), GRAIN SIZE = 4-6

Product complies w/ requirements of EU directive 2002/95/EC RoHS. Material Free from Mercury contamination.
No weld repair. NAS certifies the analysis on certification is correct & the material meets specs stated.

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

STEELMAKING PROCESS
EAF+AOD+CC

QUALITY INSPECTOR


Eric Hess

05-000003 FROM-

T-768 P023/056 F-057



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12847

Purchase Order Date 11/01/10

PO Print Date 11/01/10

Page Number 1 of 1

Order From :

VC-MET001

METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100
TORONTO, ON M4Y 3A5
CA

Contact Name

Vendor Phone 514 694 9575

Vendor Fax 514 695 3281

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
11/01/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	M304R0.4375	304 ROUND BAR 0.4375	11/11/10 Yes	12.00		\$29.4175	\$353.01

Special Inst: MATERIAL: AISI 304/316 SS ROUND
BAR AS PER ASTM A276
NOTE: AISI 303 NOT ACCEPTABLE

PO Total:

\$353.01

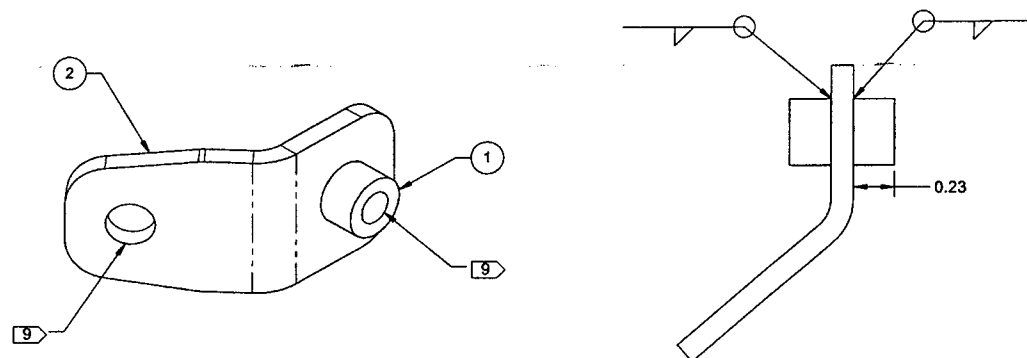
**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Change Nbr: 1

Change Date: 11/01/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5394-041	BRACKET ASSEMBLY
1	1	D5394-1	BUSHING
2	1	D5394-3	BRACKET



D5394-041 BRACKET ASSEMBLY

NOTES:

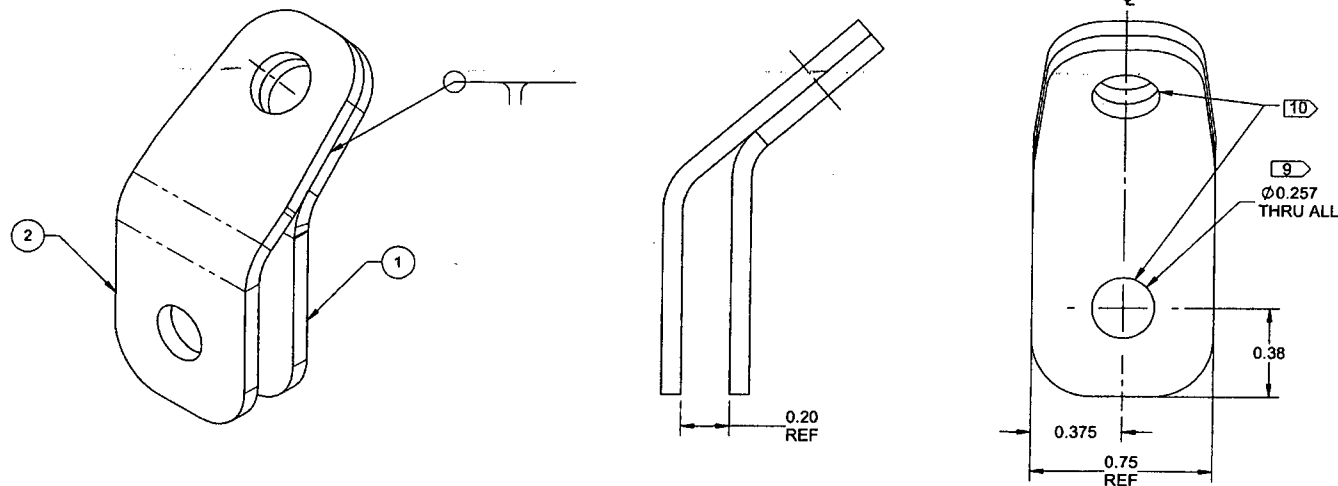
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT

RELEASED
2016-02-08
ECN 16-520

APPROVED

A	NEW ISSUE	RF	16.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5394	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	16.01.27	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5394-043	BRACKET ASSEMBLY
1	1	D5394-5	BRACKET
2	1	D5394-7	BRACKET



D5394-043 BRACKET ASSEMBLY

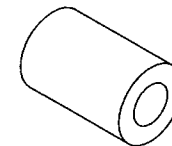
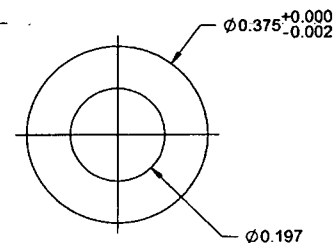
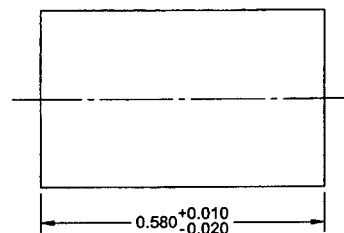
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL AFTER WELDING
- 10) MASK HOLES PRIOR TO POWDER COAT

RELEASED
2016-02-08

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5394	REV. A
MFG. APPR.	DD	SHEET 2 OF 6	
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D5394-1 BUSHING

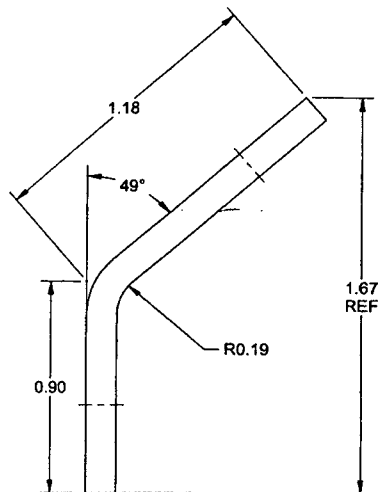
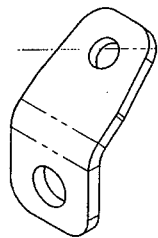
NOTES:

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND BAR
PER ASTM 276
REF. DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

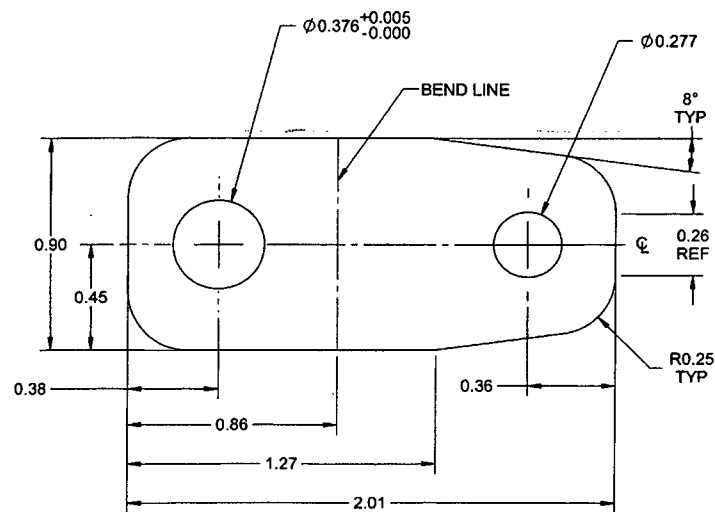
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2016-02-08

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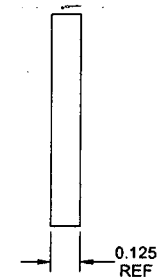
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5394	SHEET 3 OF 6
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D5394-3 BRACKET
(MAKE FROM D5394-3F)



D5394-3F FLAT PATTERN



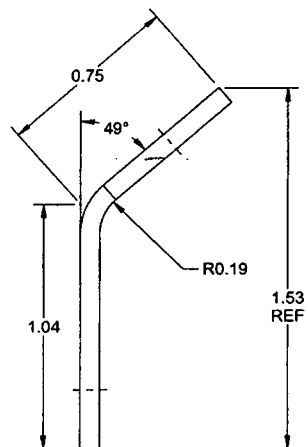
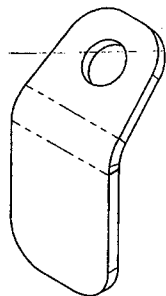
NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.125 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

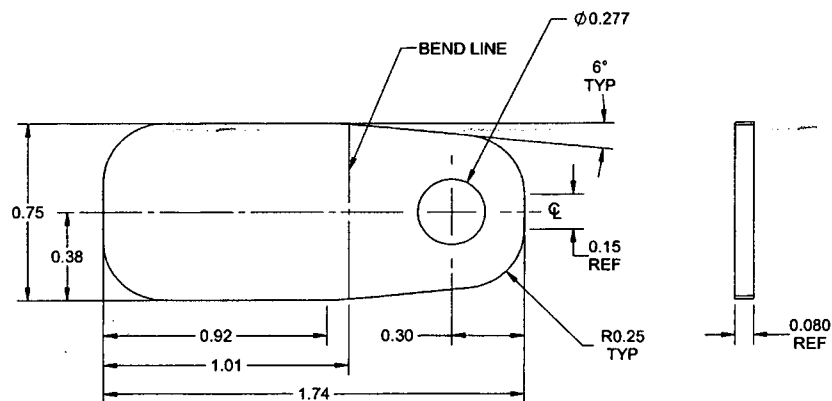
RELEASE
2016-02-08

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5394	SHEET 4 OF 6
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D5394-5 BRACKET
(MAKE FROM D5394-5F)



D5394-5F FLAT PATTERN

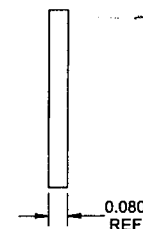
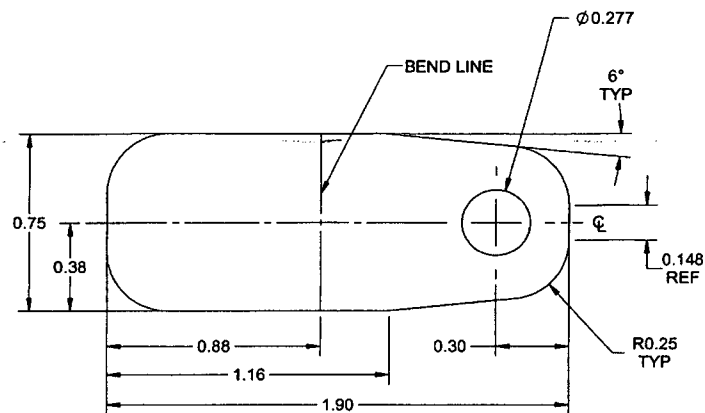
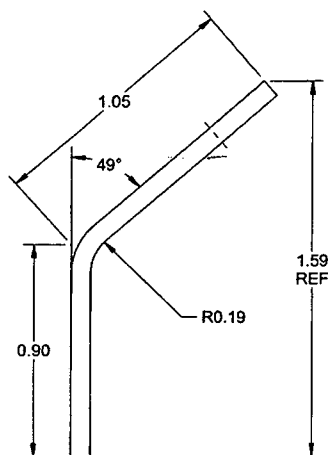
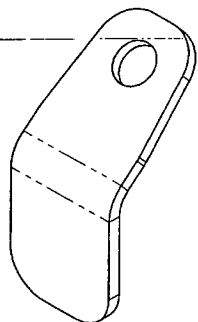
NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.080 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S14GA OR M303S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

RELEASED
2016-02-08

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	DD	D5394	SHEET 5 OF 6
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D5394-7F FLAT PATTERN

D5394-7 BRACKET
(MAKE FROM D5394-7F)

NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.080 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S14GA OR M303S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

RELEASED
2016-02-08

APPROVED

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CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5394	SHEET 6 OF 6
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